Work Order ID **110396**-2 SPLIT *110396* PRELIMINARY

December-18-13 8:50:38 AM

Item ID: D4635-3 **Accept** *N900040100* **Setup** **Start** *NS1*

Revision ID:

Item Name: Aft Ceiling Panel, LH **Stop** *NS2*

Start Date: 12/18/13 **Start Qty:** 2.00 *~~2~~* 1

Required Date: 12/31/13 **Req'd Qty:** 2.00 *~~2~~*

Cust Item ID:

Customer:

Reference:

Run **Start** *NR1*

Stop *NR2*

Approvals: **Process Plan:** ML **Date:** 13-12-18 **Tooling:** ____ **Date:** ____

QC: ____ **Date:** ____ **SPC (Y/N):** ____ **Date:** ____

Sequence ID/ Work Center ID	Operation Description	DAS 27 9-89	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**									
D4635	e ~~PB1~~	Rev E per ECN14-509								
100 *100* Thermoform Thermoforming Machine	HAND FINISHING THERMOFORMING **Memo** Cut Blanks		0.00 0.00				x2			13/12/18
105 *105* HandThermo Hand Finishing Thermoforming	Dry Material **Memo** ~~Dry Sheet as per QSI022 KYDEX~~		0.00 0.00				x2			13/12/18

Temp: 245°F

Time IN: 7:00 Am 13/12/17

Time OUT: 7:00 am 13/12/18

Work Order ID 110396

December-18-13 8:50:38 AM

110396

Item ID: D4635-3

Revision ID:

Item Name: Aft Ceiling Panel, LH

Start Date: 12/18/13 **Start Qty:** 2.00 *2*

Required Date: 12/31/13 **Req'd Qty:** 2.00 *2*

Reference:

Accept *N900040100*

Cust Item ID:

Customer:

Setup Start *NS1*

Stop *NS2*

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** ____________ **Date:** ____________ **Tooling:** ____________ **Date:** ____________

QC: ____________ **Date:** ____________ **SPC (Y/N):** ____________ **Date:** ____________

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 *110* Thermoform Thermoforming Machine	THERMOFORMING MACHINE **Memo** Thermoform as per Dwg. D4635-3 and Folio FTA149 Dwg. Rev. PD1 Folio Rev. D Visually inspect for proper formation and texture	0.00 0.00				x2			Dh. 13/12/18
130 *130* Thermoform Thermoforming Machine	HAND FINISHING THERMOFORMING **Memo** Trim to Finished Dimensions	0.00 0.00				1 1			B 14/01/11 B 13/12/22
140 *140* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB **Memo**	0.00 0.00				x1			Dh. 13/12/22

14/1/16

DAS
27
9-89

Work Order ID 110396 *110396*
December-18-13 8:50:38 AM

Item ID: D4635-3
Revision ID:
Item Name: Aft Ceiling Panel, LH
Start Date: 12/18/13 **Start Qty:** 2.00 *2*
Required Date: 12/31/13 **Req'd Qty:** 2.00 *2*
Reference:

Accept *N900040100*
Cust Item ID:
Customer:

Setup **Start** *NS1*
Stop *NS2*

Approvals: **Process Plan:** ____________ **Date:** ________ **Tooling:** ____________ **Date:** ________
QC: ____________ **Date:** ________ **SPC (Y/N):** ____________ **Date:** ________

Run **Start** *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* QC Quality Control	~~QC5~~- Inspect part completeness to step on W/O 6 DAS Memo 27 9-89	0.00 0.00 DAS 27 13/12/23 14/1/16				1 Inspected as per Dwg ~~RPI~~ PEI			
160 *160* Packaging Packaging	Packaging Memo	0.00 0.00 USE ON W/O 111206				SAD 14/01/16			
170 *170* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				MLJ 14-01-23 LL 13.12.23			

RD4397A

[illegible] RECALL
EFFECTIVE 13.12.18 AUTH
RELEASED ________ DATE ________

MF
DAS 14-1-16
27
9-89

Release Dwg Rev E 14/1/23

Picklist Print

December-18-13 8:50:43 AM

Work Order ID: 110396 *110396*

Parent Item: D4635-3 *D4635-3*

Parent Item Name: Aft Ceiling Panel, LH

Start Date: 12/18/13 **Required Date:** 12/31/13

Start Qty: 2.00 **Required Qty:** 2.00

Comments: IPP Rev. A New Issue 12/05/07 DL VERIFIED BY:JLM IPP Rev. B Dwg. Update 12/11/08 DL IPP Rev C Dwg. Ulpdate 13/07/09 DL IPP Rev. D Dwg. Update, Material Change 13/12/18 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07 *MLEXS.093-F6006-07* GE PLASTICS LEXAN SHEET		Purchased	No			100	sf	1,838.000	9.39 **	19	19	13/12/23	

Location	Loc Qty	Loc Code
MAT023	2067.26	
114459	229.26	
123105	38	
124501	1800	

DART AEROSPACE LTD		**Work Order:**	110396
Description: PANEL		**Part Number:**	D4635-3
Inspection Dwg: D4635	**Rev:** PD1		**Page 1 of 1**

FIRST ARTICLE INSPECTION CHECKLIST

THERMOFORMING SECTION

Description	**Accept**	**Reject**	**Method of Inspection**	**Comments**
Inside Radii less than N/A "				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: Dh

Date: 14/01/15

TRIMMING SECTION

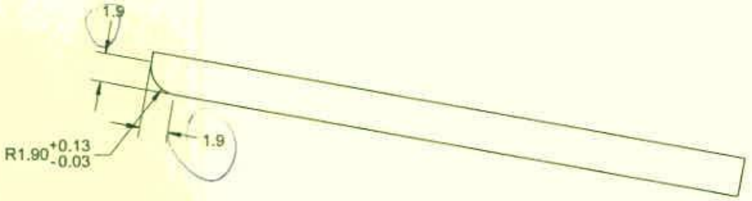
Drawing Dimension	**Tolerance**	**Actual Dimension**	**Accept**	**Reject**	**Method of Inspection**	**Comments**
40.1"		40.1"	✓			
15.46"		15.46"	✓			
Ø 3.50"		3.53"	✓			
Ø 2.03"		2.01"	✓			
Ø 0.191"		0.191"	✓			
Ø 0.179"		0.179"	✓			

Measured by:	Dh DAS 27 9-89	**Date:**	14/01/15
Audited by:		**Date:**	14/1/23
Preliminary Approval:		**Date:**	

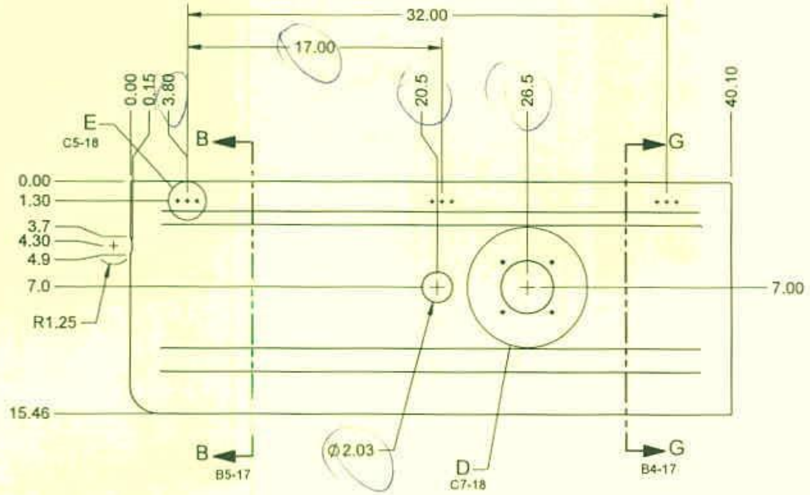
Rev	**Date**	**Change**	**Revised by**	**Approved**
B	10.04.14	Added preliminary approval	KJ	

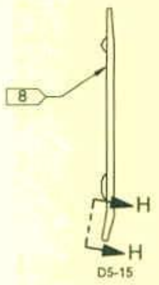
D 10.04.14

H:\FORMS\Quality Assurance\approved QA\FAIT revB



SECTION H-H B2-15





D4635-3 LH, AFT CEILING PANEL

NOTES:
1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-07)
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 2.66 lbs
8) TEXTURE ON THIS SIDE
9) TRIM D4635-3 PER TOOL DT9841
10) THERMOFORM D4635-3 PER QSI 022 USING DT9849 TOOL
MIN. THICKNESS AFTER FORMING:
RIDGES/EDGES = 0.060
ELSEWHERE = 0.070

DESIGN	RF
DRAWN	RF
CHECKED	BC
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	14.01.09

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO.
D4635
REV. PE1
SHEET 15 OF 18
TITLE
OUTBOARD CEILING PANELS
SCALE
NTS

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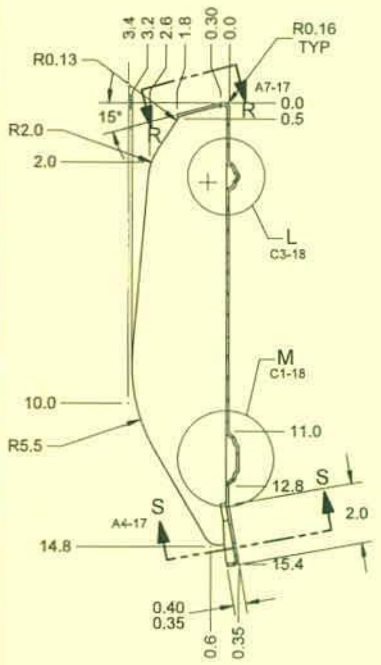

SECTION A-A
SECTION A'-A' OPPOSITE B3-13 B3-14
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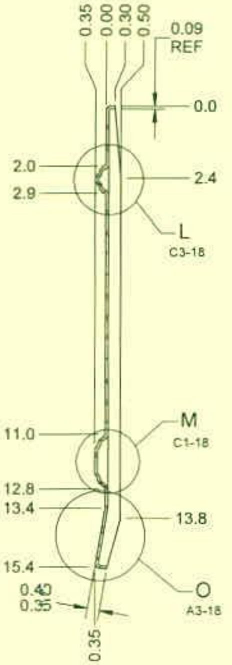

SECTION B-B B7-13 B7-14
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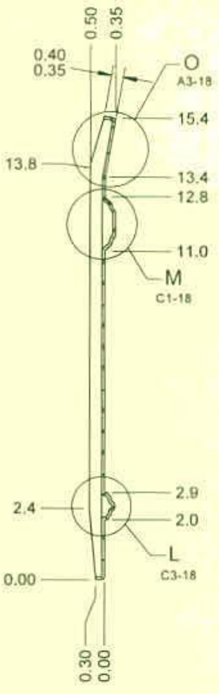

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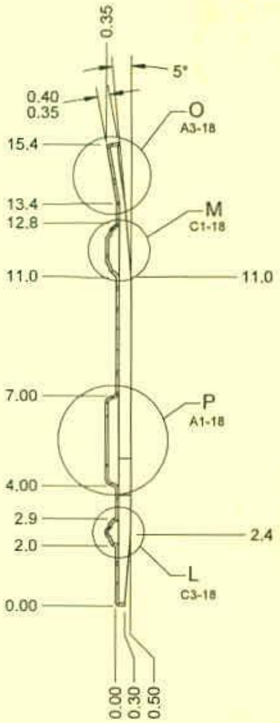

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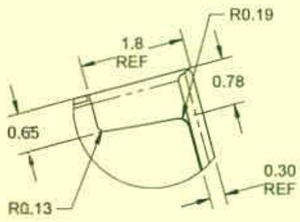
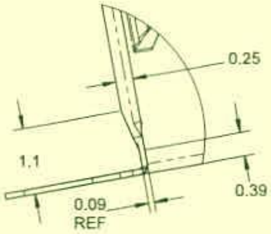


AUXILIARY VIEW R-R D7-17
SECTION R'-R' OPPOSITE
SCALE 2X



AUXILIARY VIEW S-S B7-17
SECTION S'-S' OPPOSITE
SCALE 2X

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	DRAWING NO. REV. PE1
CHECKED	DC	D4635 SHEET 17 OF 18
MFG. APPR.		TITLE SCALE
APPROVED		OUTBOARD CEILING PANELS NTS
DE APPR.		
DATE	14.01.09	

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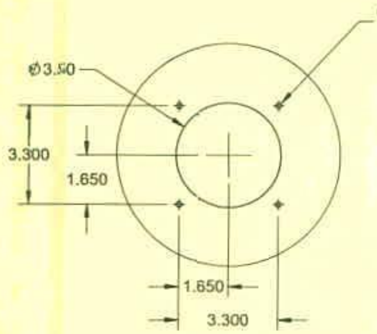

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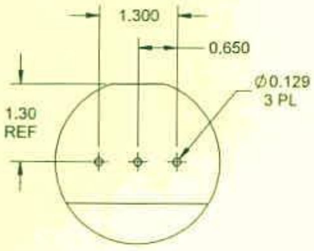
SCALE 2X



DETAIL E C7-13 B6-14 C6-15 B5-16
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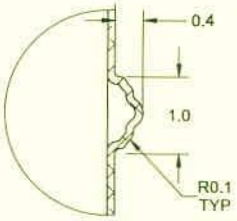

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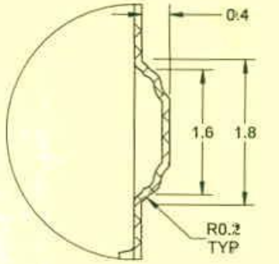

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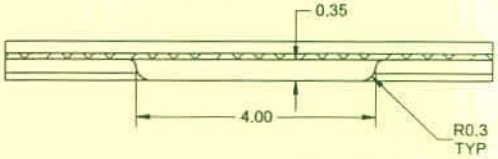

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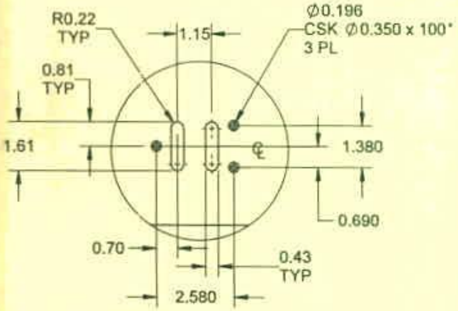

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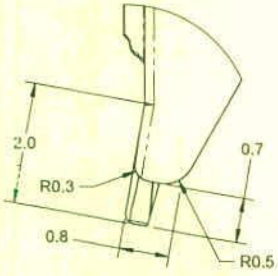

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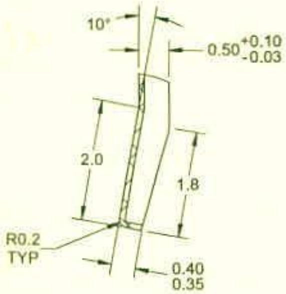

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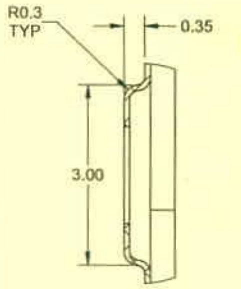

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SCALE 4X

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	BC	DRAWING NO. D4635 REV. PE1 SHEET 18 OF 18
MFG. APPR.		
APPROVED		TITLE OUTBOARD CEILING PANELS SCALE NTS
DE APPR.		
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DART AEROSPACE LTD

DART AEROSPACE

Description: aft Ceiling Panel LH

Work Order: B110396

Inspection Drawing: D4635

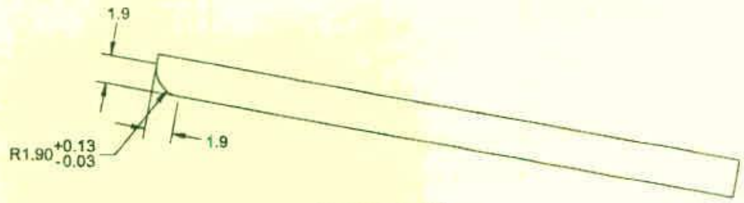
Rev: PE1

Part Number: D4635-3

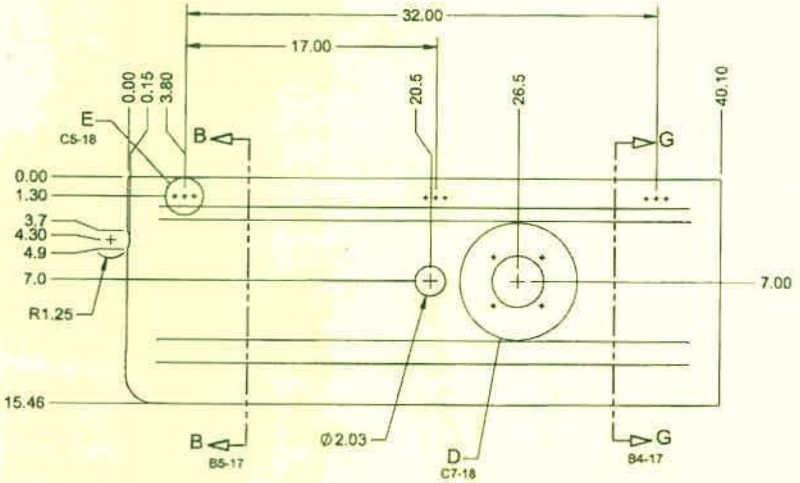
INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
32.00	+/-.030	32.00	✓		T	QCI-13
17.00	"	17.00	✓		T	"
20.5	"	20.5	✓		T	"
26.5	"	26.5	✓		T	"
Ø 2.03	"	2.04	✓		V	QCI-07
1.30	"	1.30	✓		V	"
7.00	"	7.00	✓		T	QCI-13
15.46	"	15.46	✓		T	"
1.9	"	1.91	✓		V	"
40.10	"	40.10	✓		V	QCI-07
2.0	"	2 00	✓		T	QCI-13
2.9	"	2 9	✓		T	
11.00	"	11 00	✓		T	
12.8	"	12 8	✓		T	
13 4	"	13 400	✓		T	
15 40	"	15 40	✓		T	
0 35/0 40	"	0 356	✓		T	
0 30	"	0 30	✓		T	
0 50	"	0 534	✓		T	
2 40	"	2 40	✓		T	
13 8	"	13 8	✓		T	
			✓			

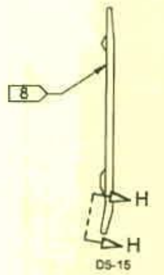
Measured by: 68-6 27 DAS	Checked By:	QC inspector:	Engineering Approval (*if necessary*):
Date 14/1/16	Date	Date	Date



SECTION H-H B2-15



D4635-3 LH, AFT CEILING PANEL



NOTES:

1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-07)
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 2.66 lbs
8) TEXTURE ON THIS SIDE
9) TRIM D4635-3 PER TOOL DT9841
10) THERMOFORM D4635-3 PER QSI 022 USING DT9849 TOOL
MIN. THICKNESS AFTER FORMING:
RIDGES/EDGES = 0.060
ELSEWHERE = 0.070

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	BC	DRAWING NO. REV. E
MFG. APPR.		D4635 SHEET 15 OF 18
APPROVED		TITLE SCALE
DE APPR.		OUTBOARD CEILING PANELS NTS
DATE	14.01.09	

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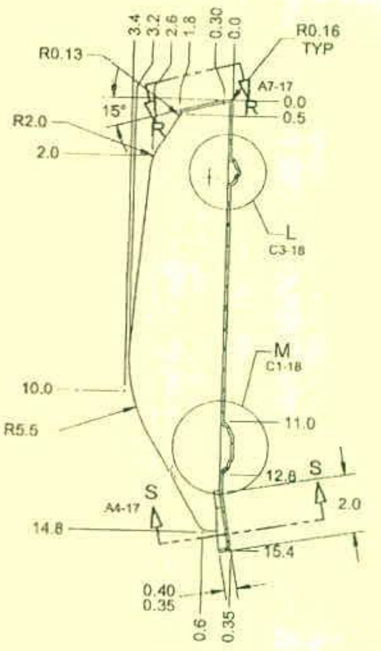
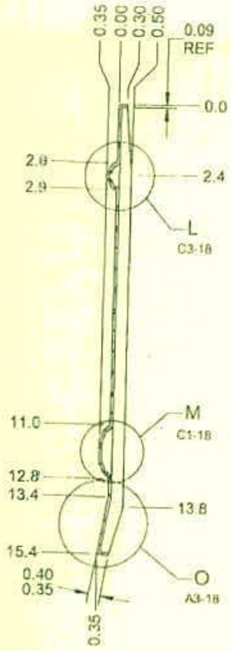


SECTION A-A
SECTION A'-A' OPPOSITE B3-13 B3-14
SCALE 2X



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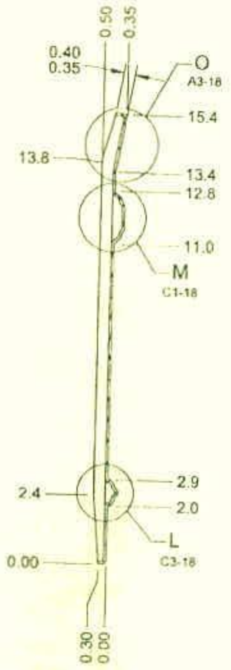

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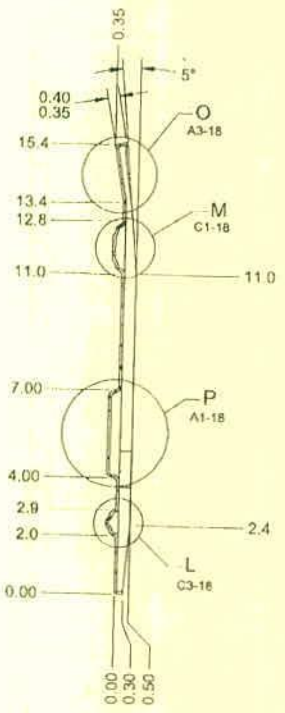
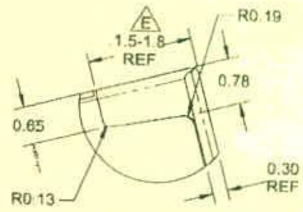
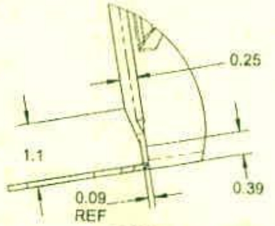


SECTION K-K C6-16
SCALE 2X



AUXILIARY VIEW R-R
SECTION R'-R' OPPOSITE D7-17
SCALE 2X



AUXILIARY VIEW S-S
SECTION S'-S' OPPOSITE B7-17
SCALE 2X

DESIGN	RF
DRAWN	RF
CHECKED	BC
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	14.01.09

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D4635
REV. E
SHEET 17 OF 18

TITLE
OUTBOARD CEILING PANELS
SCALE
NTS

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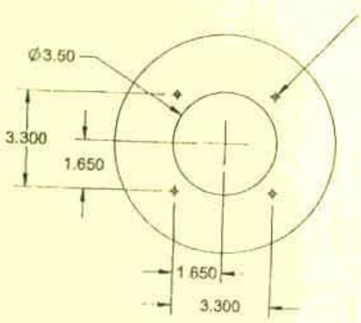
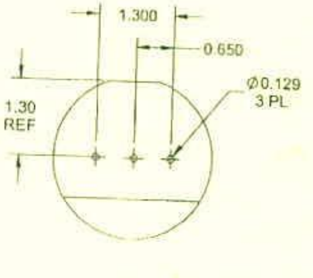
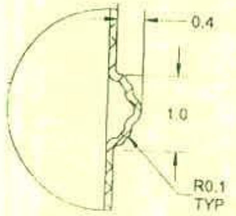


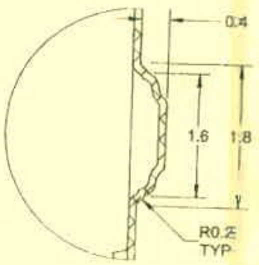
DETAIL D
SCALE 2X B4-13 B3-14 B5-15 B5-16



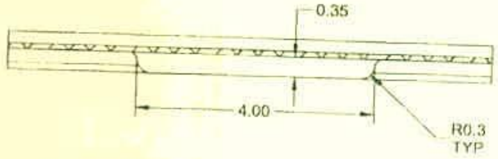
DETAIL E
SCALE 4X C7-13 B6-14 C6-15 B5-16



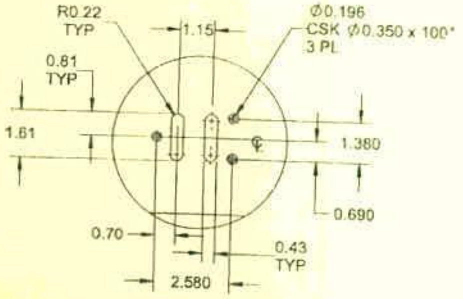
DETAIL L
SCALE 1.5X B2-17 B4-17 C5-17 C7-17



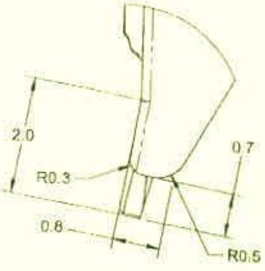
DETAIL M
SCALE 1.5X C2-17 C3-17 C5-17 C7-17



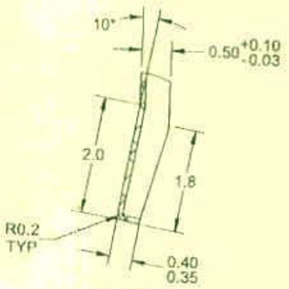
SECTION I-I
SCALE 4X B5-16



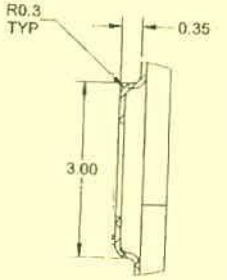
DETAIL Q
SCALE 2X C5-16



DETAIL N
SCALE 2X B2-13



DETAIL O
SCALE 2X D2-17 D3-17 B5-17



DETAIL P
SCALE 4X C2-17

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	BC	DRAWING NO. D4635 REV. E SHEET 18 OF 18
MFG. APPR.		
APPROVED		TITLE SCALE OUTBOARD CEILING PANELS NTS
DE APPR.		
DATE	14.01.09	

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